



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4150-3
Job Sheet 169917



23

Part No: D4150-3

Job Qty: 20 ea

Part Name: Arm Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/15/18

Description:

Type: Stock

Note: DWG REV B IPP Rev:A 10.06.24 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		1/13/18	0.00	0.00	Start Up Waterjet		ac 18/01/09
100	Waterjet	20 pcs		1/15/18	0.00	1.31	Waterjet1		ac 18/01/09
120	QC	20 pcs		1/15/18	0.00	0.00	QC8		38
150	Packaging	20 pcs		1/15/18	0.00	0.00	Packaging3	STOP1	4-380 18-01-12
160	QC21-SA	20 Ea		1/15/18	0.00	0.00	QC21		DAS 21 JAN 16 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	1	81	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm Plate	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
2	Arm Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
3	Arm Plate	1.000Inches ± 0.010	1.010 0.990		
4	Arm Plate	0.968Inches ± 0.010	0.978 0.958		
5	Arm Plate	0.375Inches ± 0.010	0.385 0.365		
6	Arm Plate	0.300Inches ± 0.010	0.310 0.290		
7	Arm Plate	0.800Inches ± 0.010	0.810 0.790		
8	Arm Plate	1.590Inches ± 0.030	1.620 1.560		
9	Arm Plate	2.340Inches ± 0.030	2.370 2.310		
10	Arm Plate	0.750Inches ± 0.030	0.780 0.720		
11	Arm Plate	1.560Inches ± 0.030	1.590 1.530		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Engineering Quality Other ☐ ☐ ☐																																													
Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																													
Description Work Order Deviation																																																	
Root Cause <table style="width: 100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pressure/Forced ☐</td> <td>Temperature ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Dam ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection In ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contaminatic ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions In ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="2" rowspan="2">OTHER : _____</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>		Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Dam ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection In ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contaminatic ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions In ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____		Misidentified ☐	Past Due ☐	D4150-3 Start up Operation Mfg Date: 01/09/18 Job No: 169917 PART NO: S030342 Revision: Operation: Change No:	
		Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature ☐																																												
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IRB (QSI042) Approval _____ Completed By _____ hand / Supervisor roval Verification _____ QA Coordinator Approval _____																																																	
ied Wrong Dimensions der tolerance rrect 'Missing id Turning Sequence _____																																																	

Plex 1/3/18 11:21 AM dart.poulin.mario

13	Arm Plate	0.125inches $\pm$ 0.010	0.135 0.115
12	Arm Plate	1.188inches $\pm$ 0.010	1.178 1.198

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D4150-3 Revision: Arm Plate														
160	QC21-SA	S030342	169917	23 Ea	0	S030342	ST081	Bin	Stock	1/9/2018	Issue Container			
Operation Totals:		1		23	0									
Part Totals:		1		23	0									
Part Number: M304S11GA Revision: 304/316 0.125 Sheet														
100	Receive sf	S030341	169917	1 sf	0	M138109	Start Up Waterjet		Stock	1/9/2018	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Totals:		2		24	0									

Plex 1/16/2018 9:50 AM Dart.Lajeunesse.Marie